

Date: Thursday, 05/06/2008 8:49:26 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE		
Job Number	: 39716		Part Number	: D353525		
Estimate Number	: 12734		Drawing Number	: D3535 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 05/06/2008 S.O. No. :		Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 10/06/2008		
Previous Run	: 38867			Qty: 30 Um: Each		
Written By	:			10/06		
Checked & Approved By	:					
Comment	: Est Rev:A New Issue 07-02-15 JLM					
	Est Rev:B As per Rev B 07-08-31 JLM		Verified By:EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet 28.
		Comment: Qty.: 0.5355 sf(s)/Unit Total : 16.0650 sf(s) 304/316 .040 Sheet (M304S20GA) Batch: 108156 HB 8-6-9
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: B HB 8-6-9 Prog Rev: B
		39
3.0	QC2	2-Deburr if necessary HB 8-6-9 INSPECT PARTS AS THEY COME OFF MACHINE
		HB 8-6-9
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		508/06/10 X38 coated
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE 1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261and DT8326 2-Form joggle on Punch as per Dwg D3535 using Jig DT8158Identify as D3535-25 58 08/06/11 E808/06/12 39

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 05/06/2008 8:49:26 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 39716

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



co-centre

8/06/12 X 39

Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



39X

M105642

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 1:00 pm

OVEN TEMPERATURE: 320° F

FINISH TIME: 1:30 p.m.

m-1 08/06/12

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



39

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



39X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-17

m-1 08/06/12

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/06/13 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-13

W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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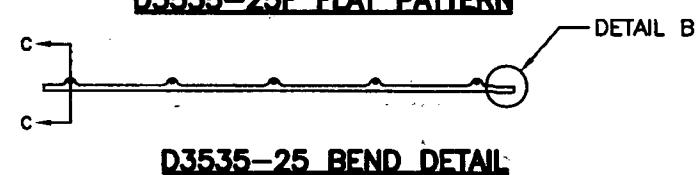
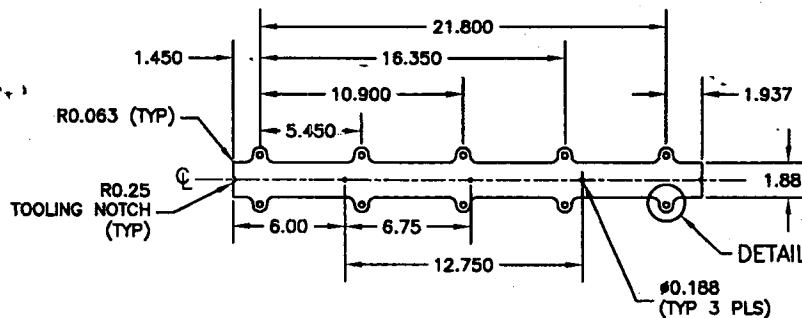
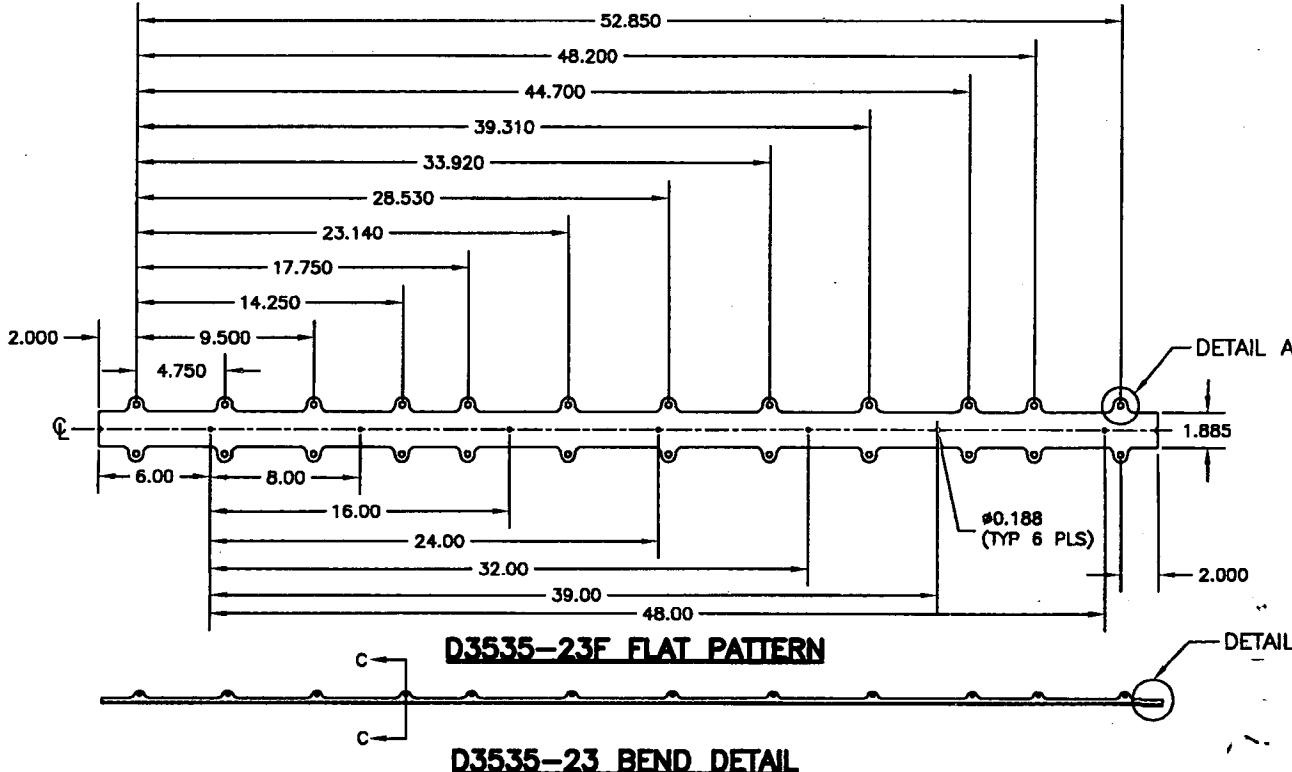
NOTE: Date & initial all entries

DART

DESIGN C8	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED H	APPROVED H	DRAWING NO. D3535
DATE 07.04.17		TITLE WEARSHOE

RELEASED

07.04.24

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/I/O:		WORK ORDER CHANGES					
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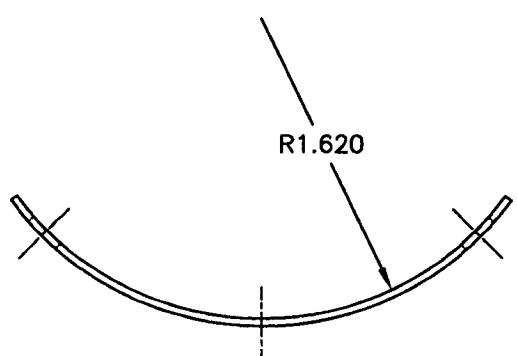
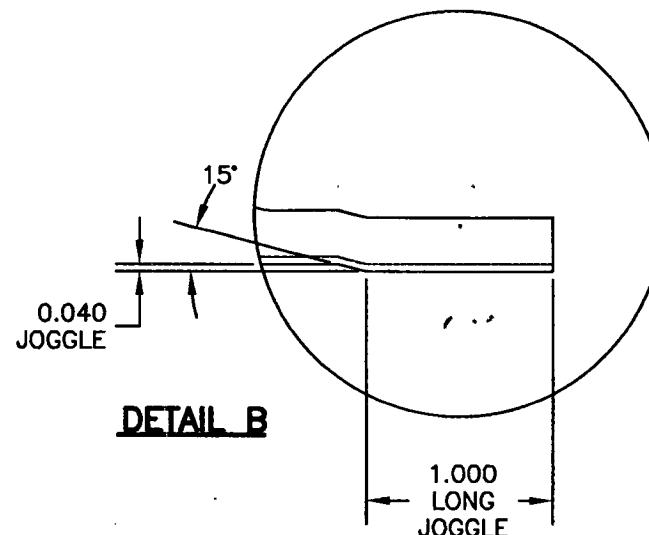
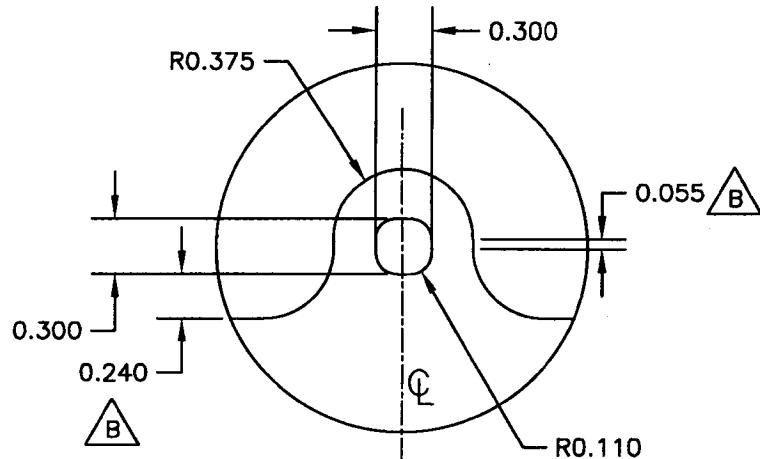
NOTE: Date & initial all entries

DART

RELEASED

07.04.24

DESIGN C-B	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17		SHEET 7 OF 7
		SCALE 1:1
		TITLE WEARSHOE



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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39716
Description: WEAR SHOE	Part Number:	D3535-25
Inspection Dwg: D3535-25 Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>BS</u>	Audited by: <u>S</u>	Prototype Approval: <u>✓</u>
Date: <u>8-6-9</u>	Date: <u>08/06/10</u>	Date: <u>7</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

